

54678 DRU

Work Order ID 53785



Page 1

November 18, 2009 12:39:55 PM

Item ID: D3235-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Mounting Lug

Start Date: 18/11/2009 Start Qty: 60.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan: RLDate: 09/11/18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3235

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.820" □ Batch:

45800

DJT 09/12/03

62

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA369 and Dwg D3235 □ 2-Identify as D3235-1 □ 3-Debur

DJT 09/12/12

62

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DJT 09/12/12

62

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector








Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____




Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

November 18, 2009 12:39:55 PM

Item ID:	D3235-1	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Mounting Lug					
Start Date:	18/11/2009	Start Qty:	60.00		Cust Item ID:	
Required Date:	25/11/2009	Req'd Qty:	60.00		Customer:	
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop
						
						

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00	BP 09/12/14			62			
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00	BP 09-12-15			62			
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00	Sc 02/12/15			+62			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector








Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

November 18, 2009 12:39:55 PM

Item ID:	D3235-1	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Mounting Lug					
Start Date:	11/11/2009	Start Qty:	60.00		Cust Item ID:	
Required Date:	25/11/2009	Req'd Qty:	60.00		Customer:	
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop
						
						

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53785

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Item ID:	D3235-1	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Mounting Lug					
Start Date:	18/11/2009	Start Qty: 60.00		Cust Item ID:		
Required Date:	25/11/2009	Req'd Qty: 60.00		Customer:		
Reference:						
Approvals:	Process Plan:	Date:	Tooling:		Run	Start
	QC:	Date:	SPC (Y/N):			Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/12/17 *[Signature]*
09-12-14
(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 18, 2009 12:40:03 PM

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Work Order ID: 53785

Parent Item: D3235-1RevA

Parent Item Name: Mounting Lug

Comments:

Start Date: 18/11/2009

Required Date: 25/11/2009

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3235-1PRevA		Purchased	No			100	Each	0.0000	60.0000			
lug												
D2423RevB1		Manufactured	No			110	f	658.2039	4.3137			
Lug Extrusion												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	658.2039221	
43722	207.263091	
44529	22.39	
45800	428.550832	

4.3137 DIT 09/12/09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	53785
Description: Mounting Lug		Part Number:	D3235-1
Inspection Dwg: D3235	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

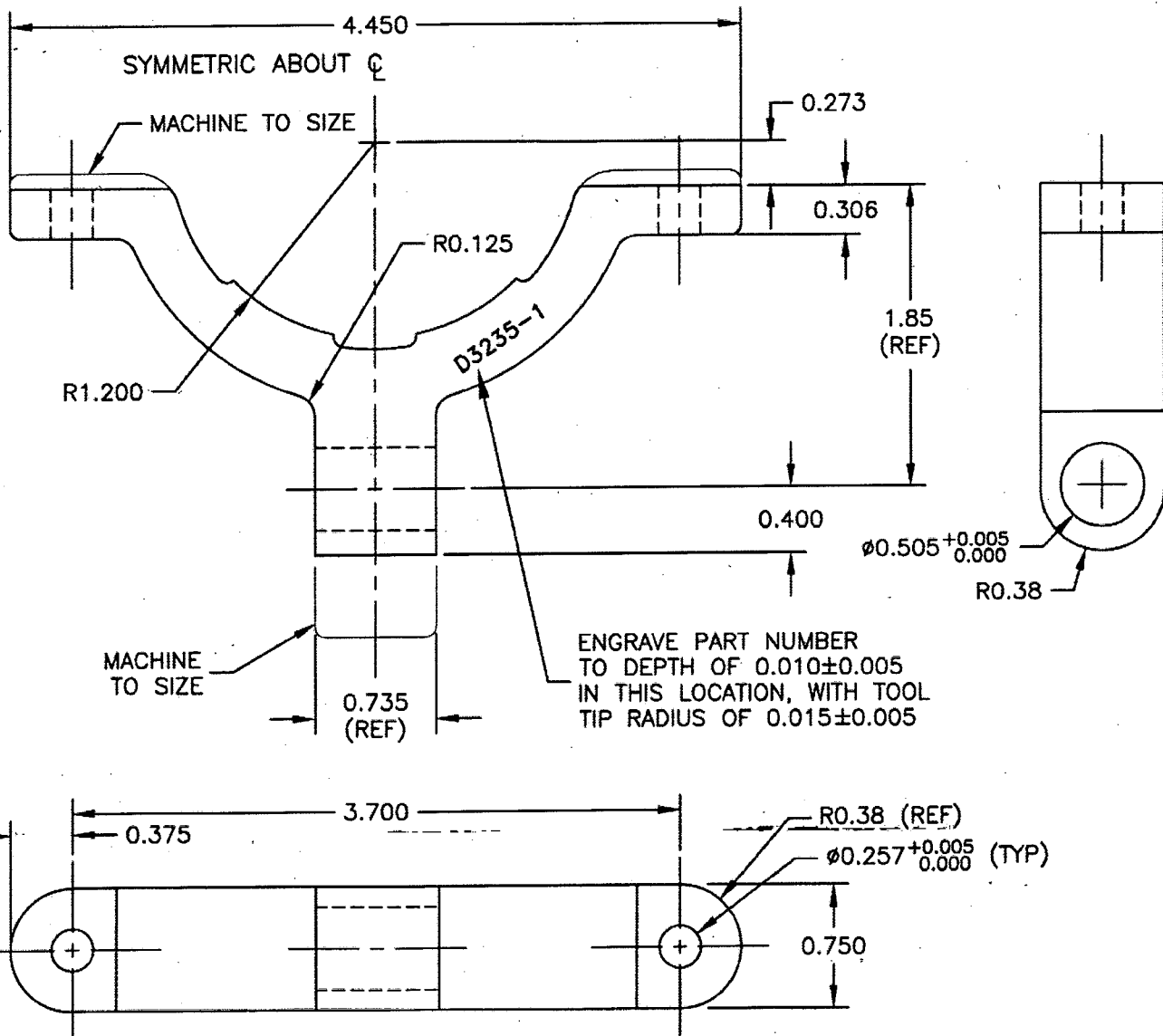
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010	4.450	✓			
0.306	+/-0.010	0.308	✓			
1.85	+/-0.030	1.843	✓			
R1.20	+/-0.010	1.200	✓			
R0.125	+/-0.010	0.125	✓			
0.400	+/-0.010	0.401	✓			
0.735	+/-0.030	0.725	✓			
Ø0.505	+0.005/-0.000	0.507	✓			
R0.38	+/-0.030	0.38	✓			
0.273	±0.010	0.272	✓			
3.700	+/-0.005	3.700	✓			
0.375	+/-0.010	0.375	✓			
0.750	+/-0.010	0.750	✓			
Ø0.257	+0.005/-0.000	0.260	✓			
R0.380	+/-0.030	0.380	✓			

Measured by:	DJP	Audited by:	SP	Prototype Approval:	N/A
Date:	09/12/12	Date:	69/12/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	

DART

DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3235	REV. A NO. <i>10-09-11-16</i>
DATE 04.03.02		TITLE MOUNTING LUG SCALE 1:1	
A	04.03.02	NEW ISSUE	

RELEASED
040405**D3235-1 MOUNTING LUG**

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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